

Work Order ID 80425

80425

Page 1

February-21-12 9:10:37 AM

Item ID: D3639-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 21/02/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: M.L.J.

Date: 12/02/12

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3639

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3639

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B12-2-23

(8)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-2-23

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

W 12 02 24 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80425

80425

Page 2

February-21-12 9:10:37 AM

Item ID: D3639-4 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Doubler
 Start Date: 21/02/2012 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 06/03/2012 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE					⑨			
Brake NC	Memo	0.00		SB 12/02/27					
Brake NC	Form as per Dwg D3639								
140		0.00							
140	QC5- Inspect part completeness to step on W/O					⑤			
QC	Memo	0.00		8/2/02/27					
Quality Control									
150		0.00							
150	Chemical Conversion Coat per QSI005 4.1					⑨			
HandFinish	Memo	0.00							
Hand Finishing									

⑨ 7/6/12-2-28

W/O:		WORK ORDER CHANGES					
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Page 3

February-21-12 9:10:37 AM

Item ID: D3639-4 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 21/02/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 06/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location 8244	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

Handwritten: 9 4 12/02/29

Handwritten: (9x) SP12-02-29.

Handwritten: MLS 12/02/29

Handwritten: ME 12-02-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-21-12 9:10:40 AM

Page 1
1

Work Order ID: 80425

80425

Parent Item: D3639-4

D3639-4

Parent Item Name: Doubler

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	68.6000	0.4277	3.601684			

M2024T3S 050

**

B12-2-23

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT022

68.6

117684

68.6

117684

8

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80425
Description: Doubler		Part Number:	D3639-4
Inspection Dwg: D3639	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.624	X		U Bx2	
Ø0.191	+0.005/-0.001	.191	?		U	
Ø0.098	+0.004/-0.001	.098	>		U	
0.45	+/-0.030	.447	>		U	
1.350	+/-0.010	.349	>		U	
2.25	+/-0.030	2.246	>		U	
3.15	+/-0.030	3.151	>		U	
4.05	+/-0.030	4.052	>		U	
4.95	+/-0.030	4.948	>		U	
5.85	+/-0.030	5.847	>		U	
6.75	+/-0.030	6.748	>		U	
7.65	+/-0.030	7.655	>		U	
8.55	+/-0.030	8.558	>		T Bx1	
9.350	+/-0.010	9.366	>		T	
9.45	+/-0.030	9.460	>		T	
10.350	+/-0.010	10.349	>		T	
11.25	+/-0.030	11.252	>		T	
12.15	+/-0.030	12.118	>		T	
12.85	+/-0.030	12.85	>		T	
13.86	+/-0.030	13.86	>		T	
13.96	+/-0.030	13.96	>		T	
0.805	+/-0.010	.802	>		U	
1.00	+/-0.030	1.001	>		U	
2.100	+/-0.010	2.099	>		U	
3.30	+/-0.030	3.306	>		U	
2.000	+/-0.010	2.000	>		U	
2.590	+/-0.010	2.581	>		U	

Measured by:	B
Date:	12-2-23

Audited by:	W W
Date:	12-02-24

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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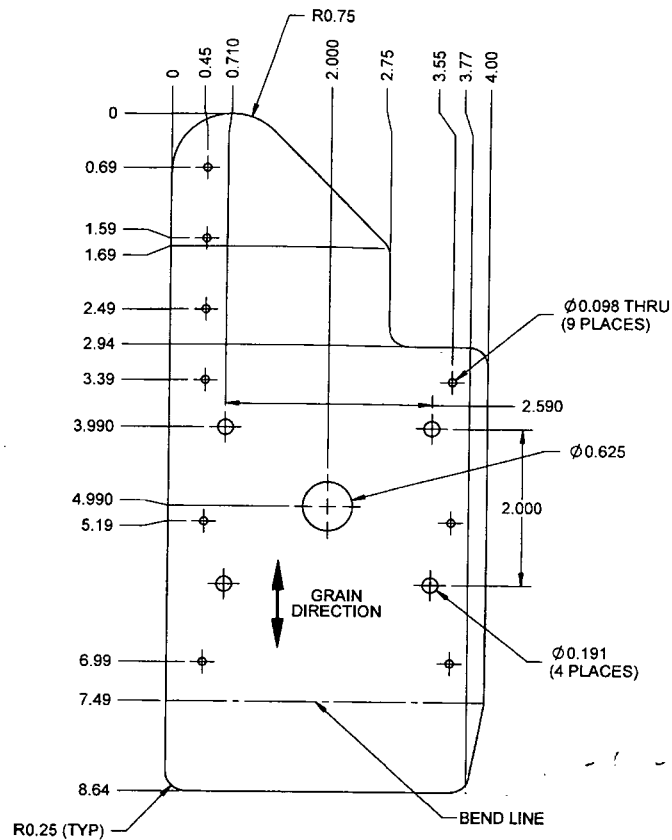
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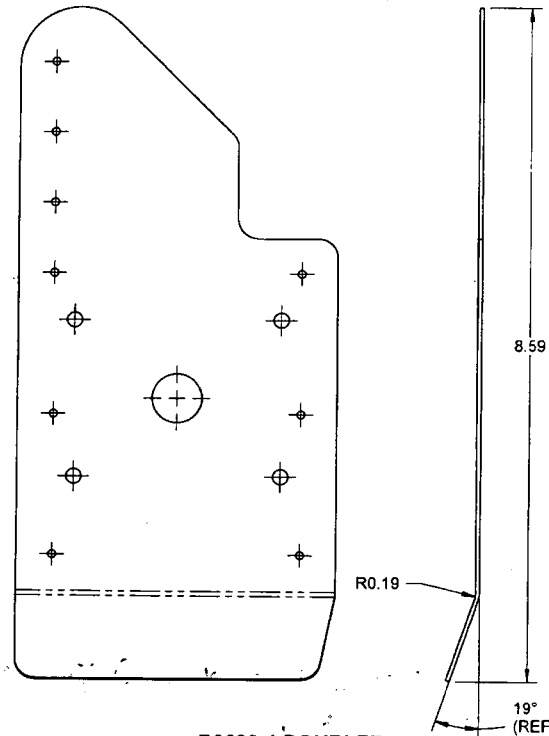
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B

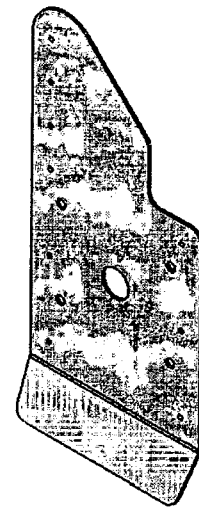
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**D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)**



**D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)**



D

C

B

A

80425 M.C.J
12/02/21

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.14 lbs

UNCONTROLLED
SUBJECT TO

RELEASED
07.07.27

A		NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.		DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. A SHEET 1 OF 2	
DRAWN	LE				
CHECKED	BE	DRAWING NO.		REV. A	
MFG. APPR.	BE	D3639		SCALE	
APPROVED	BE	TITLE		SCALE	
DE APPR.	BE	DOUBLER		2:3	
DATE		07.07.27		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

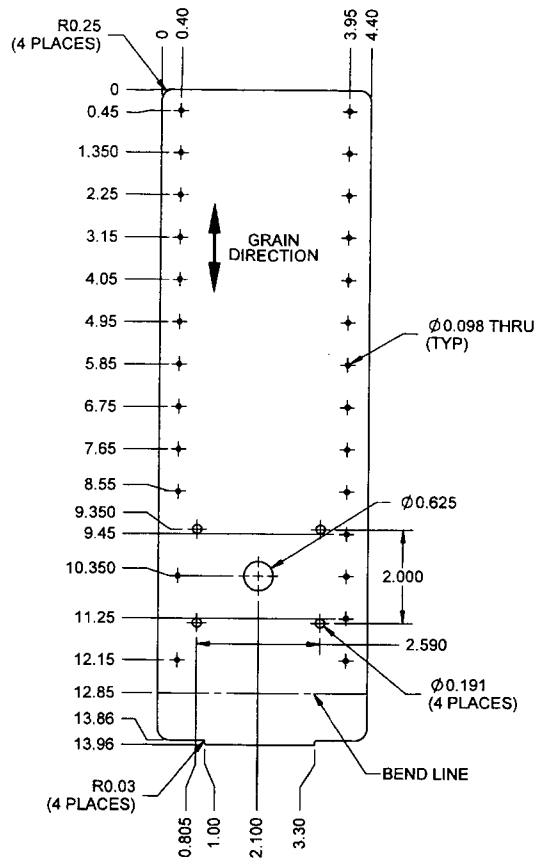
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

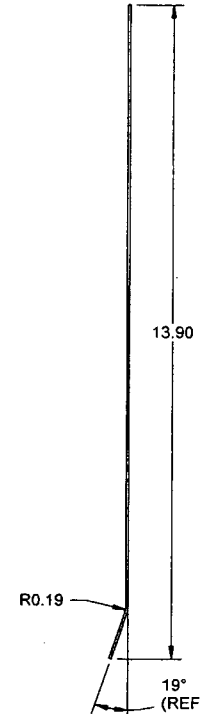
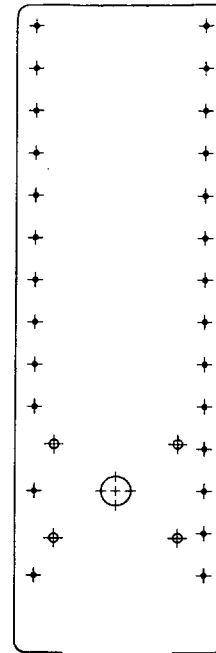
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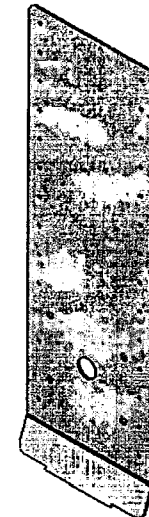
80425



**D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)**



**D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)**



RELEASED
07-09-07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	D3639	SHEET 2 OF 2
APPROVED	BE	TITLE	SCALE
DE APPR.	BE	DOUBLER	2:1
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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